

Work Order ID 50043

July 6, 2009 1:28:12 PM



Page 1

Item ID: D3053-042
Revision ID: B
Item Name: 212 Basket Base Assembly

Accept



Setup Start



Stop



Start Date: 07/06/2009 Start Qty: 1.00

Required Date: 07/10/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3053	Rev B								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut 5 D2235-3 FROM D3166-1 using DT8365; 12-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995								
110		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Remove all markings from material 112-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required								
120		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									

(P12) → ~~last page~~

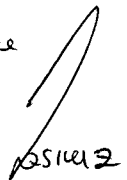
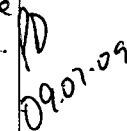
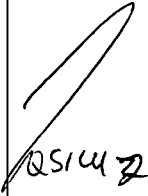

SAD 09-07-07

PD 09-07-10

CP 09-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3053-042 PAR #: N/A Fault Category: Res - Lge Fab NCR: Yes No DQA: NA Date: 09-07-10
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: NA Date: 05-06-17

NCR: 50043		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.07.09	100 i 110	Part D3053- was drilled incorrectly. Sec. between C & D was drilled by mistake. Should have been C-C. RC: Human error / LOA to detail.		fill the affected holes on the ~3 rib with weld per AS1004. Grind flush & ensure there is no foreign objects in the rib or bracket. Drill C-C per drawing & remove all debris.		S 01/02/10		

NOTE: Date & initial all entries

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Start Date: 07/06/2009 Start Qty: 1.00
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Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 27	5026716		(86)				
140 DC Document Control	DOCUMENT CONTROL Memo Take Traveller D205-541-043 to KP	0.00 0.00							
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo START TIME: 9:20AM FINISH TIME: 9:50AM PRESSURE WASH 09-07-10 OVEN TEMPERATURE: 400F M112148 . 09-07-10	0.00 0.00							

BA

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Required Date: 07/10/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

09-07-10

①

BR



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

W/O 50039

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/10

W 09/07/10

Picklist Print

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Work Order ID: 50043

Parent Item: D3053-042RevB

Parent Item Name: 212 Basket Base Assembly


Comments:

Start Date: 07/06/2009

Required Date: 07/10/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			110	Each	15.0000	2.0000			
												
Basket Hinge												


Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 15

47263 3

48443 12

D2327-3RevD		Manufactured	No			110	Each	78.0000	2.0000			
												
Spacer Bushing												


Warehouse Loc Qty Loc Code
Location

Premier

Mezz 78

44274 69

44365 9

D2581RevA1		Manufactured	No			110	Each	35.0000	2.0000			
												
Mounting Bracket												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 35

46086 2

48428 33

1

PD 09.07.08

2

PD 09.07.09

2

PD 09.07.09

Picklist Print

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Work Order ID: 50043

Parent Item: D3053-042RevB

Parent Item Name: 212 Basket Base Assembly

Comments:

Start Date: 07/06/2009

Required Date: 07/10/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3166-1RevA1		Manufactured	No			110	Each	0.0000	5.0000			
Basket Hoop												
M304EX0.75-16F		Purchased	No			100	sf	886.5700	50.5263			
Expanded Metal Flat SS												

B48491 → 1
B48573 → 4 PD 09-07-07

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
MAT	886.57	
108152	90	
110134	6.7	
110292	14.4	
110629	14.41	
110861	21.18	
110992	0.58	
111444	17.79	
111630	35.15	
111956	46.36	
112147	640	

- 10.60
- 40.5263 SMO 09-07-08

Picklist Print

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Parent Item Name: 212 Basket Base Assembly

Comments:

Start Date: 07/06/2009

Required Date: 07/10/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	680.8900	45.6140			



304 SQ Tube .75x.75x.065W

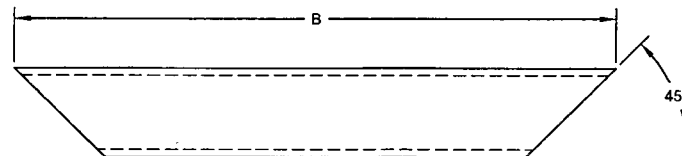
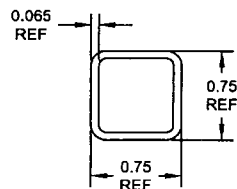
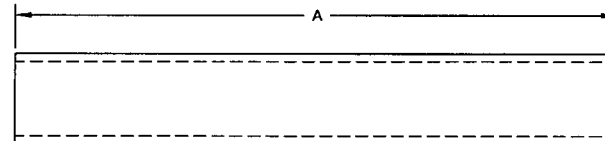
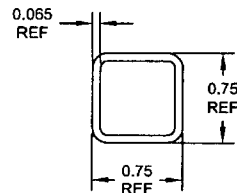
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	680.89	
110969	3.29	
111148	15.96	
111331	1.96	
111432	0.44	
111885	25.14	
112051	634.1	

45.6140 SAW 09-07-07

PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB

REFERENCE ONLY



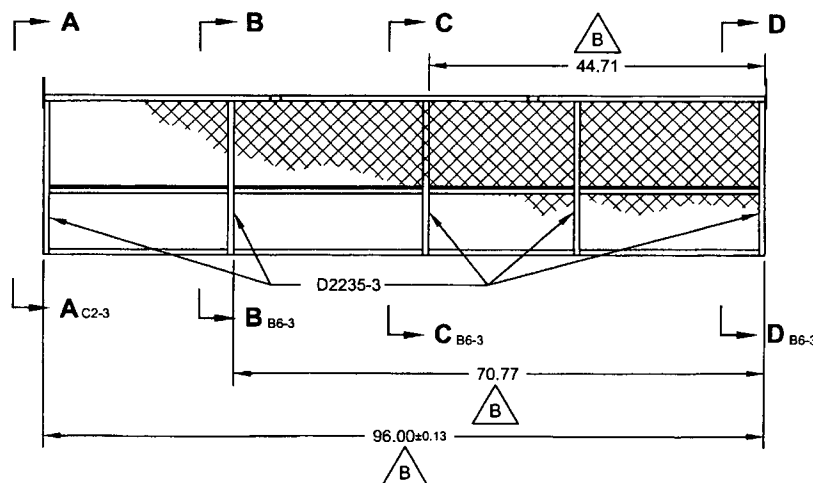
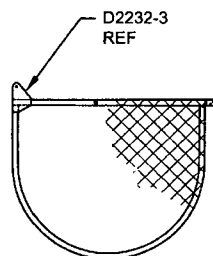
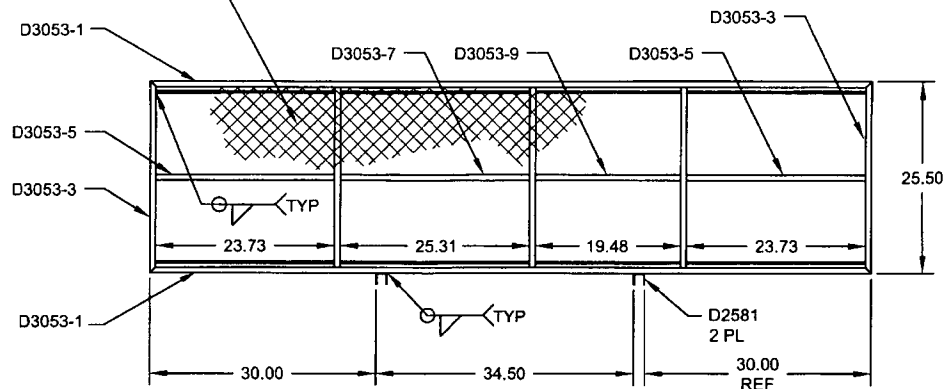
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

RELEASED
09-07-06

B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	08.07.02	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



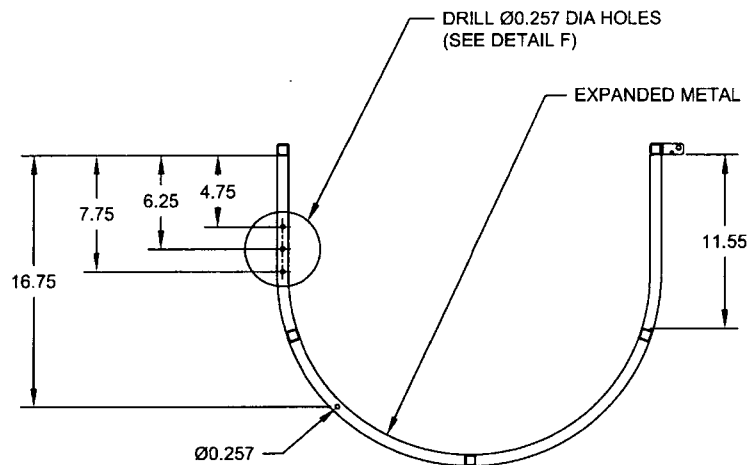
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09-07-00

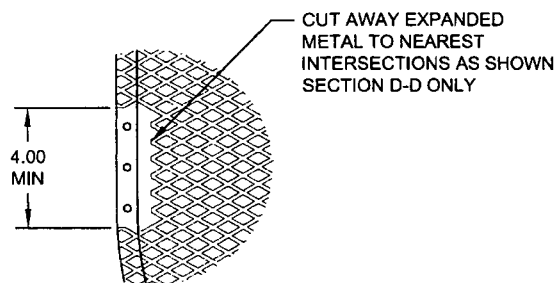
RELEASED

D3053-042 BASKET BASE ASSEMBLY SHOWN
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)

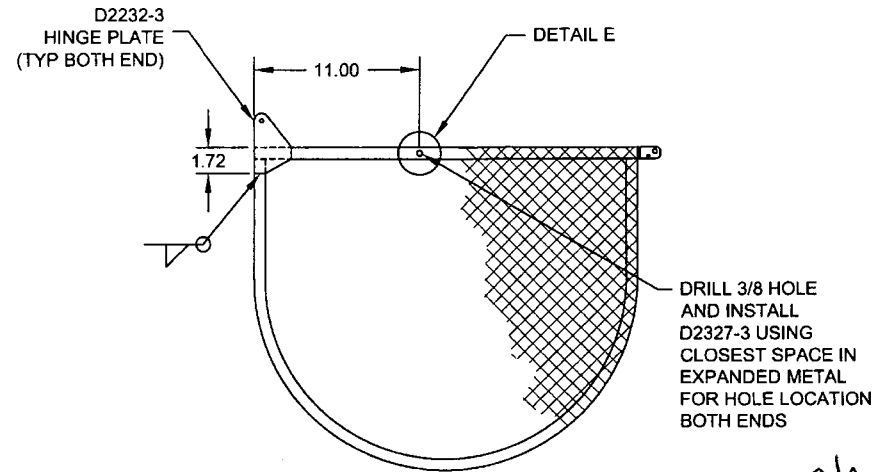
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	08.07.02	COPYRIGHT © 2001 BY DART AEROSPACE LTD	
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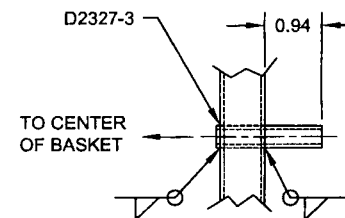
SECTION B-B_{B5-2}
SECTION C-C_{B4-2}
AND SECTION D-D_{B3-2}
RIB DETAIL



DETAIL F
SCALE NONE



SECTION A-A_{B6-2}
SPACER DETAIL



DETAIL E
SCALE 4X

09-07-04
REFERENCE ONLY

RELEASED
 08 35 21 144

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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